

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
7 July 2005 (07.07.2005)

PCT

(10) International Publication Number
WO 2005/061201 A1

(51) International Patent Classification⁷: **B29C 44/34**,
44/58, 45/00

(21) International Application Number:
PCT/CA2004/002194

(22) International Filing Date:
23 December 2004 (23.12.2004)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
60/532,269 23 December 2003 (23.12.2003) US

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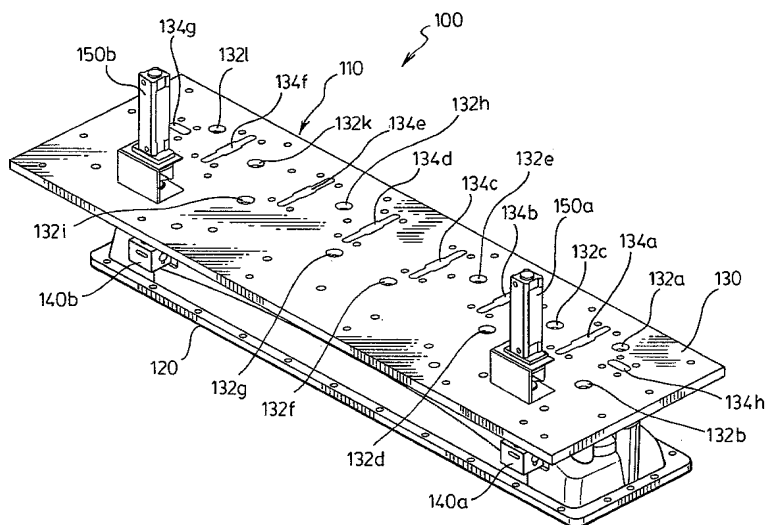
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(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM,

[Continued on next page]

(54) Title: ARTICLE, METHOD AND APPARATUS OF FORMING EXPANDED PLASTIC MATERIALS IN A STEAM CHEST MOLD



(57) Abstract: The invention provides an article, a method and an apparatus of forming expanded plastic materials in a steam chest mold having out of die draw features. This is achieved by means of a cavity pull system. The cavity pull system allows for the provision of molded features outside the die draw and is designed to operate on a cam type system using two stainless steel rods running at a right angle to one another. A gear mechanism allows molded features, e.g. holes, to be formed at any angle on any part design where enough part geometry exists to accommodate the forming features and in the tool for mechanism components. The invention is advantageously employed in the formation of holes outside the die draw in vertically stacked injection tools for energy absorbers used in vehicle bumper fascias. The provision of out of die draw molded features is useful for fascia component locating or attachment.

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ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

Published:

— *with international search report*

— *before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendments*

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